

Date: Wednesday, 18/06/2008 1:27:45 PM
User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WELDMENT TOP PANEL		
Job Number	39934				
Estimate Number	13030				
P.O. Number	:	Part Number	: D36505		
This Issue	: 18/06/2008	S.O. No. :	: D3650 REV.B		
Prsht Rev.	: NC	Project Number	: N/A		
First Issue	: / /	Drawing Revision	: B		
Previous Run	: 36943	Material	:		
Written By	:	Due Date	: 07/07/2008		
Checked & Approved By	: <u>JWD 08.6.18</u>	Qty:	2 Um: Each		
Comment	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC				
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	M304S26GA	304/316 0.018 SHEET			
		3.			
Comment: Qty.: 0.8537 sf(s)/Unit Total : 1.7073 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: <u>108415</u> <u>HB 8-6-26</u>					
2.0	WATER JET	FLOW WATER JET			
					
Comment: FLOW WATER JET 1-Cut as per Dwg D3650 Dwg Rev: <u>B</u> <u>HB 8-6-26</u> ③ Prog Rev: <u>B</u>					
2-Deburr if necessary <u>HB 8-6-26</u>					
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
		<u>HB 8-6-26</u> 			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE					
4.0	QC8	SECOND CHECK			
		<u>S 08/07/01 (X3)</u> 			
Comment: SECOND CHECK					
5.0	BRAKE NC	NC BRAKE			
		<u>HB</u> 			
Comment: NC BRAKE Form as per Dwg D3650 <u>AS</u> <u>08.07.14</u> <u>2</u>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/10	5.0	Press operator bent D3650-5, according to Dwg. But Dwg operator error Bent opposite to Dwg. R.C. Dwg's were not consistent. to each other R.C. Human error	Initial Chief Eng	Scrap and Destroy Replace B&B 108415 08/01/10	108415 08/01/10	108415 08/07/10	108415 08/07/10	108415 08/07/10
				Fit Dwg's so they can be bent correctly				

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:27:46 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 39934

Part Number: D36505

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/15 (3)

7.0 D36507

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
SEAL 3.000

batch B 39950

FF 08-07-17 (3)

8.0 D36509

Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
ANGLE 3.000

batch B 39951

FF 08-07-17 (3)

9.0 AN960C4

WASHER



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)
WASHER 36.000

batch M 106431

FF 08-07-17 (3)

10.0 NAS9307M403

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)
RIVET 36.000

batch M 106433 M 105940

FF 08-07-17 (3)

11.0 MS20427M33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)
Rivet 24.000

batch M 106993

FF 08-07-16 (3)

12.0 MS210603K

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
Nut Plate 6.000

batch M 105938

FF 08-07-16 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:27:46 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 39934

Part Number: D36505

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS210623K

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
6.000

Nut Plate
batch M 105938

FF 08-07-16

(3)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3650

FF 08-07-16

(3)

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/17 (3)

16.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock
Location CA

88 08/07/17

(3)

17.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/07/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39935
Description: Fwd Panel	Part Number:	D3650-5
Inspection Dwg: D3650 Rev: B		Page 1 of 1

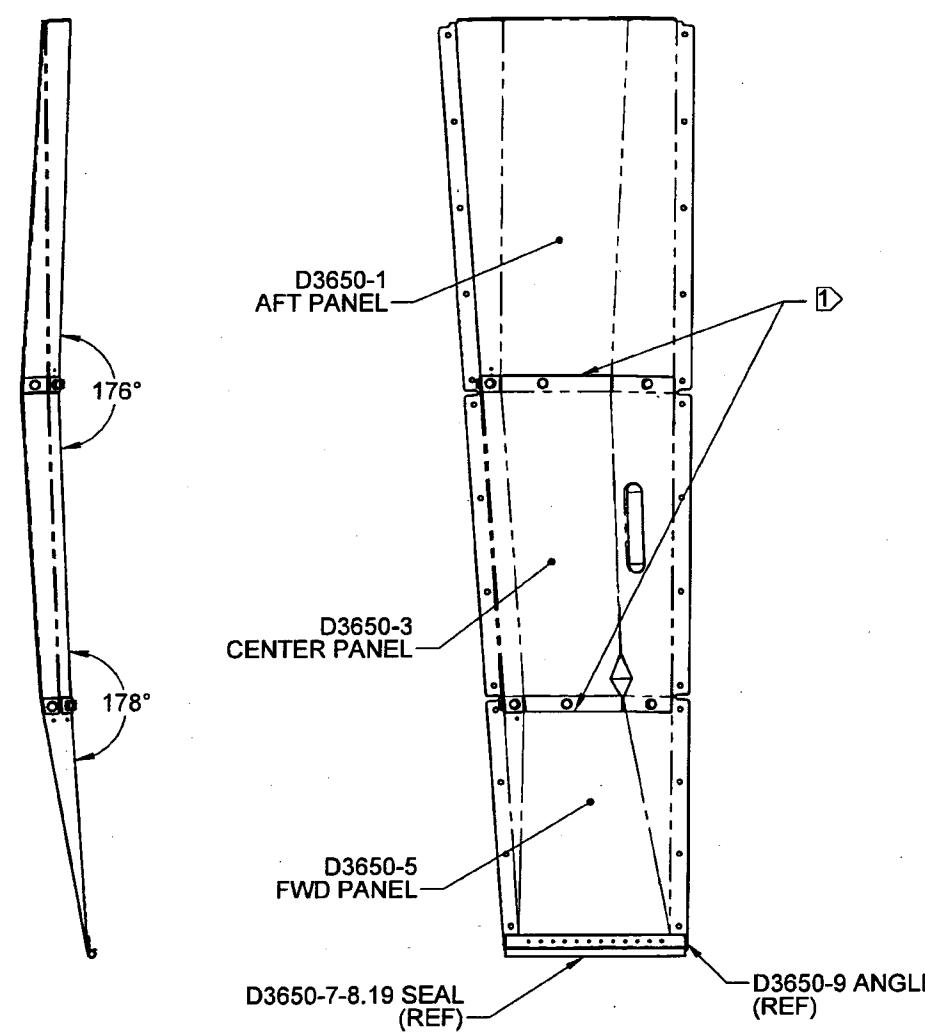
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	J	Prototype Approval:	N/A
Date:	8-6-26	Date:	05/07/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	

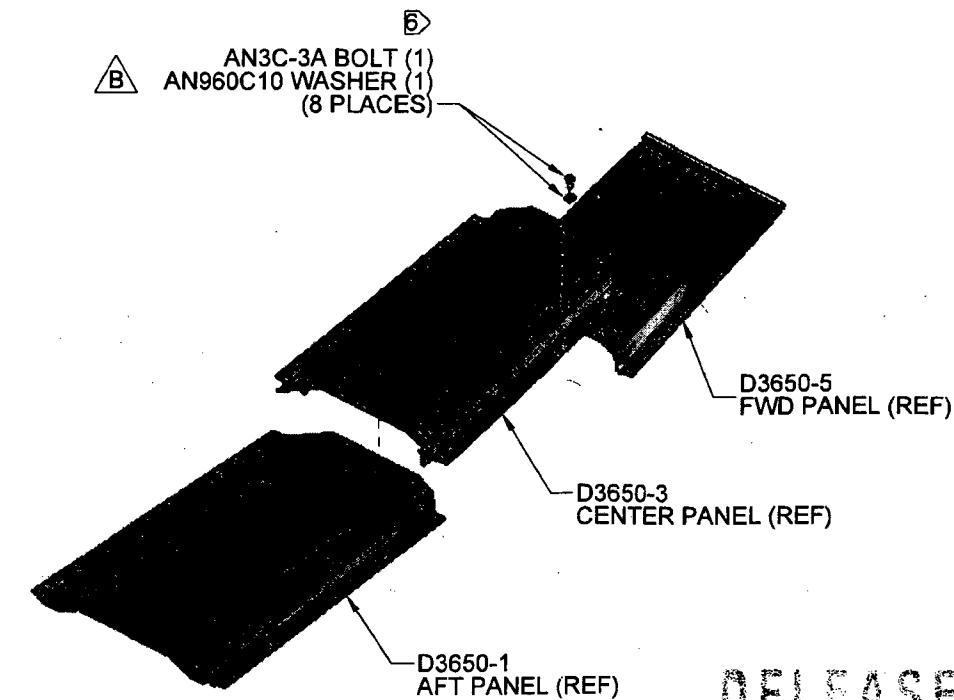
8 7 6 5 4 3 2 1



D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs



RELEASED
08-03-17

PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

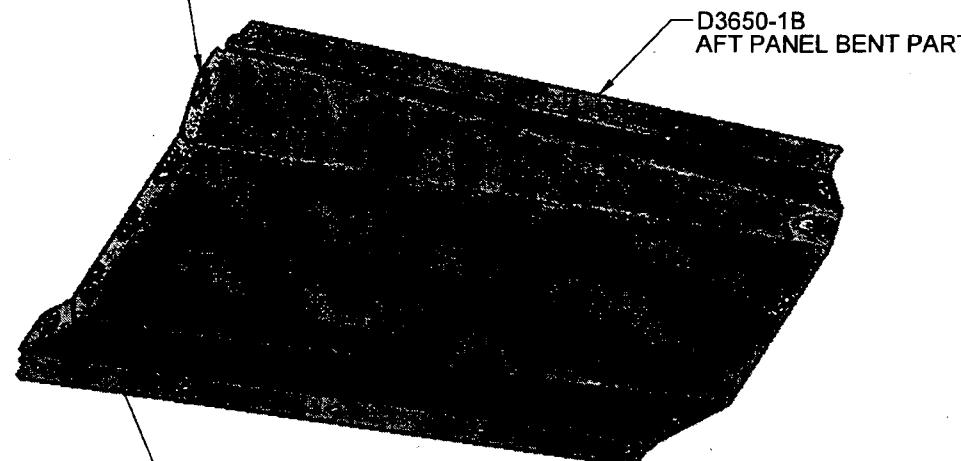
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 6: REMOVED/RELOCATED HOLES, UPDATED VIEWS SHEET 4: 1.8 WAS 1.5, 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11-11F FROM SHEET 6; UPDATED DIMS OF D3650-11-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 1 OF 9
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	TOP PANEL ASSEMBLY	1:8
DATE	08.01.07	COPRIGHT © 2007 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NO. A 3901

8 7 6 5 4 3 2 1

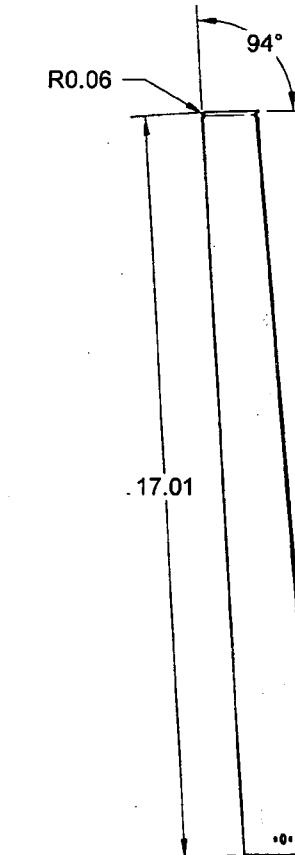
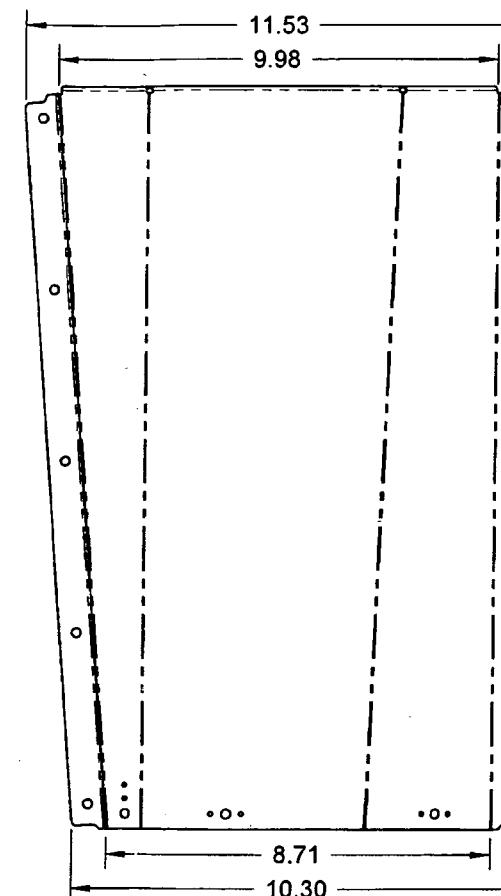
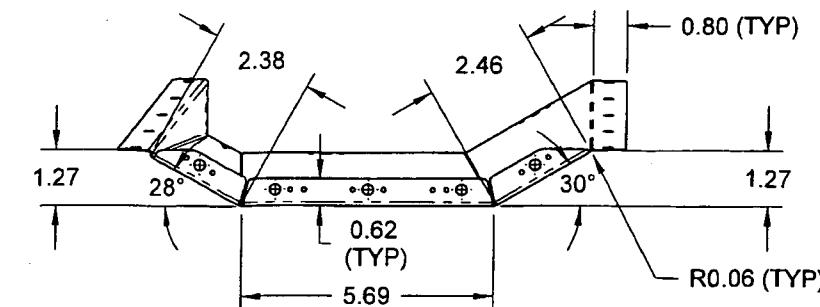
B
MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(6 PLACES)



D3650-1B
AFT PANEL BENT PART

MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(3 PLACES)

D3650-1 AFT PANEL

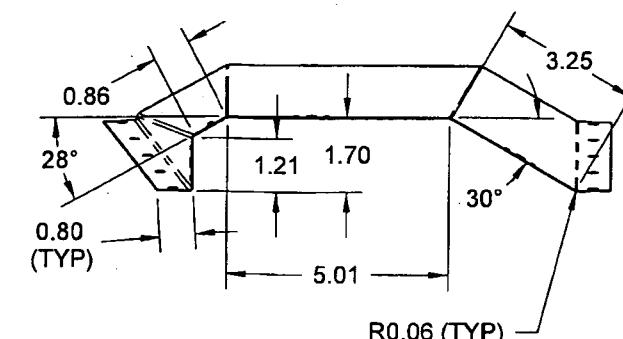


D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

PART LIST

QTY	PART NUMBER	DESCRIPTION
-1	X D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

B



NOTES:
 1) FINISH: NONE
 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 5) IDENTIFICATION: NONE
 6) WEIGHT: 1.3 lbs

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	LL	DRAWING NO.	
MFG. APPR.	MM	REV. B	
APPROVED	MM	D3650	
DE APPR.	MM	SHEET 2 OF 9	
DATE	08.01.07	TITLE	
		SCALE	
		TOP PANEL ASSEMBLY	
		1:4	

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8

7

6

5

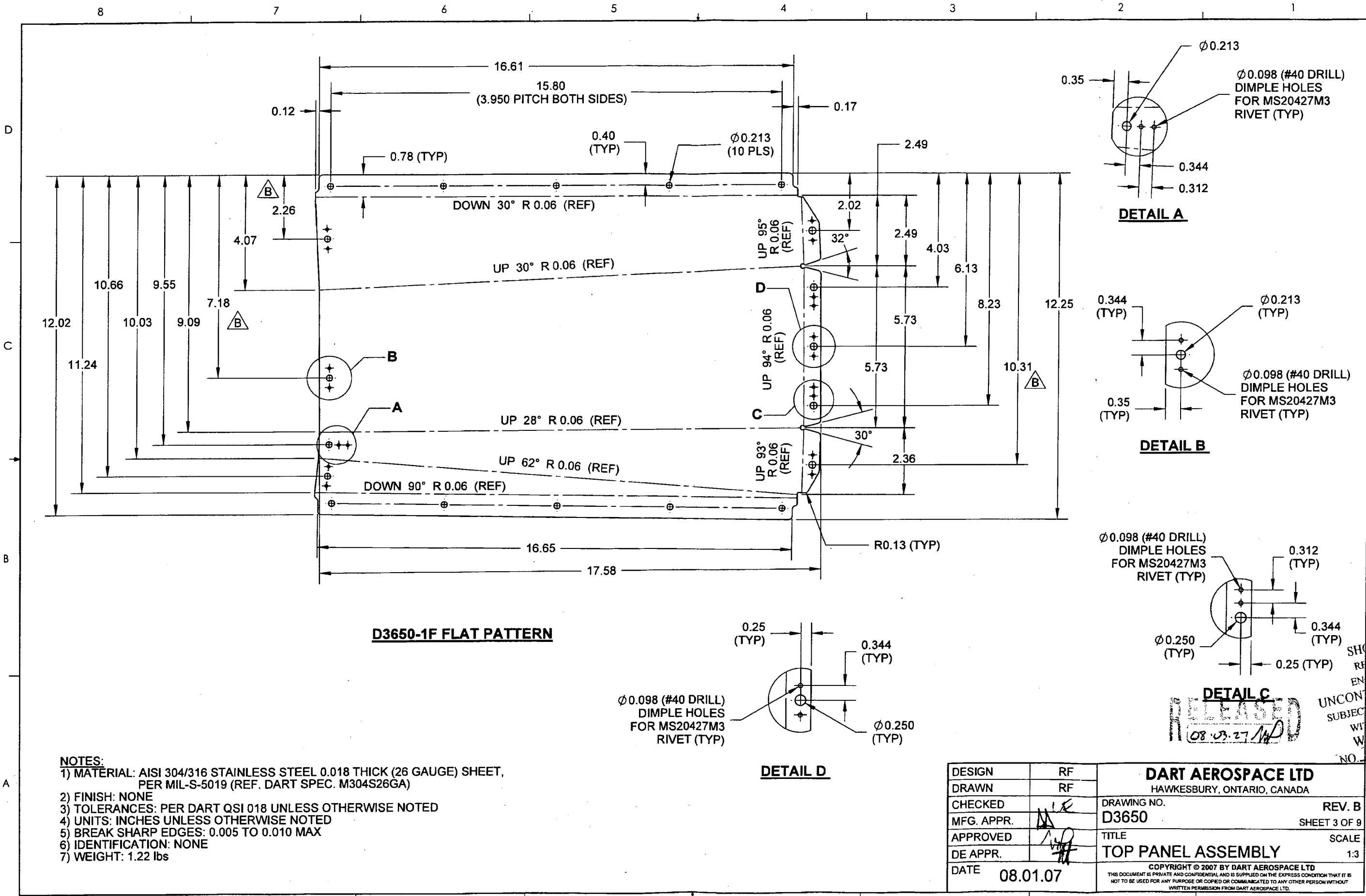
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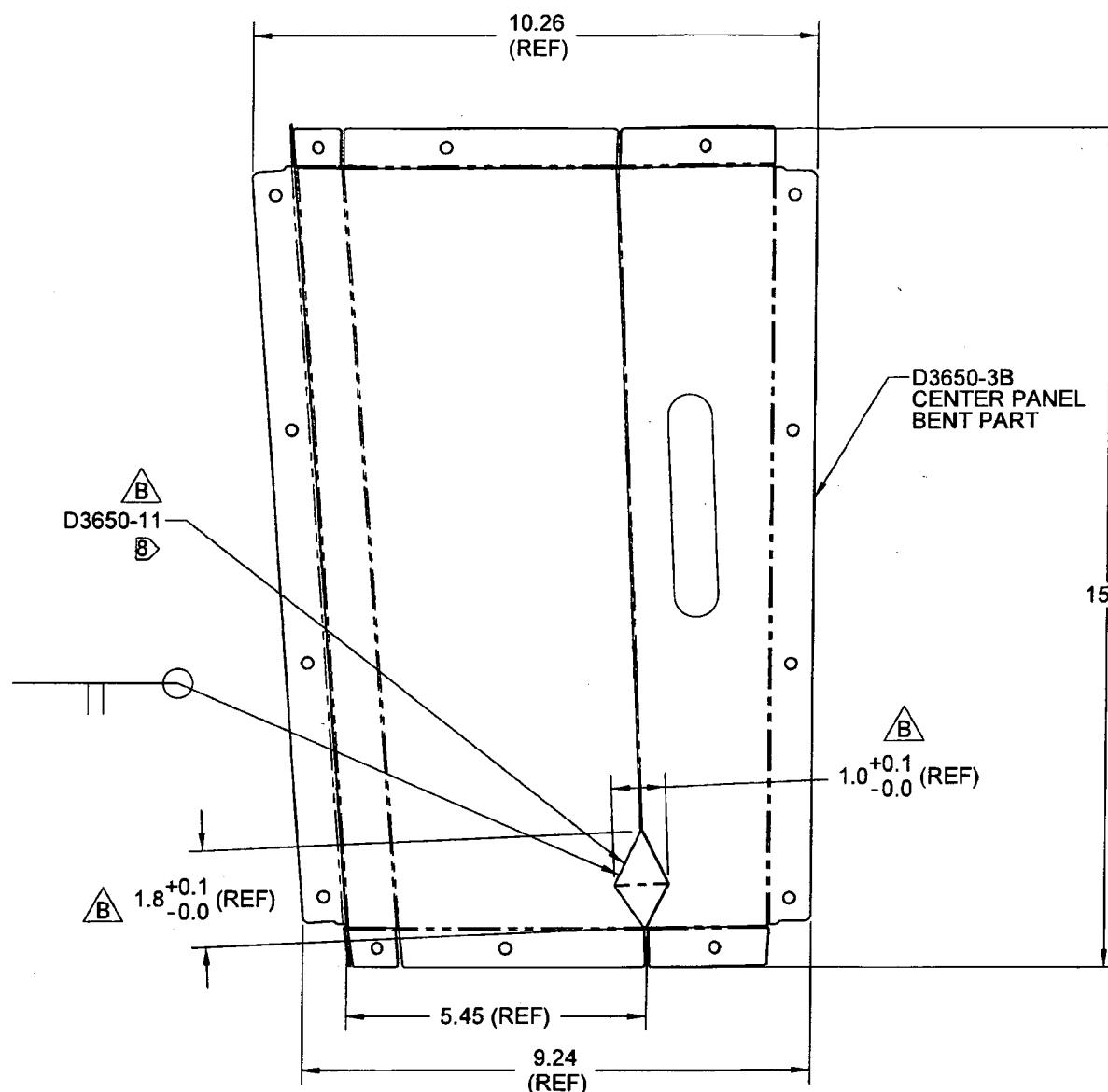
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1

A



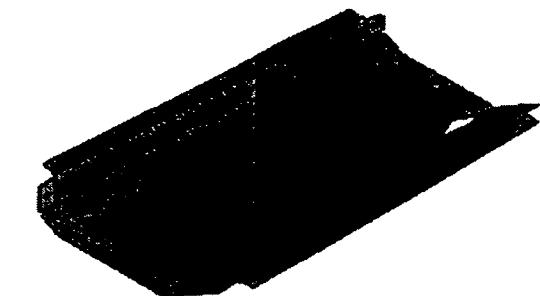
8 7 6 5 4 3 2 1



D3650-3 CENTER PANEL

NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED



PART LIST

QTY	PART NUMBER	DESCRIPTION
-3	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

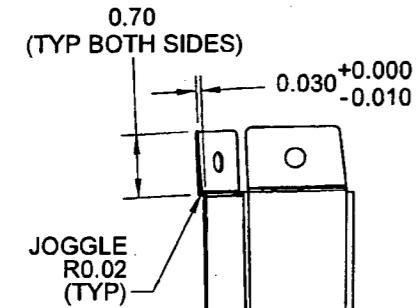
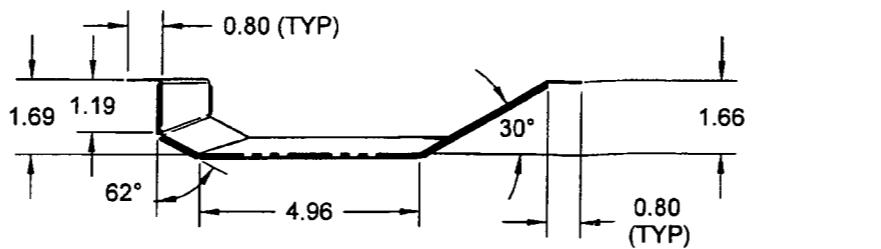
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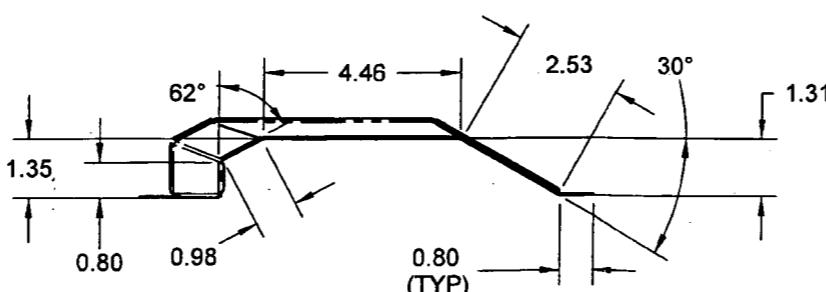
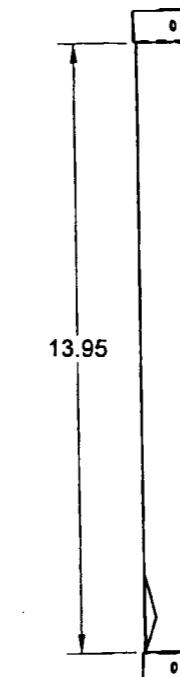
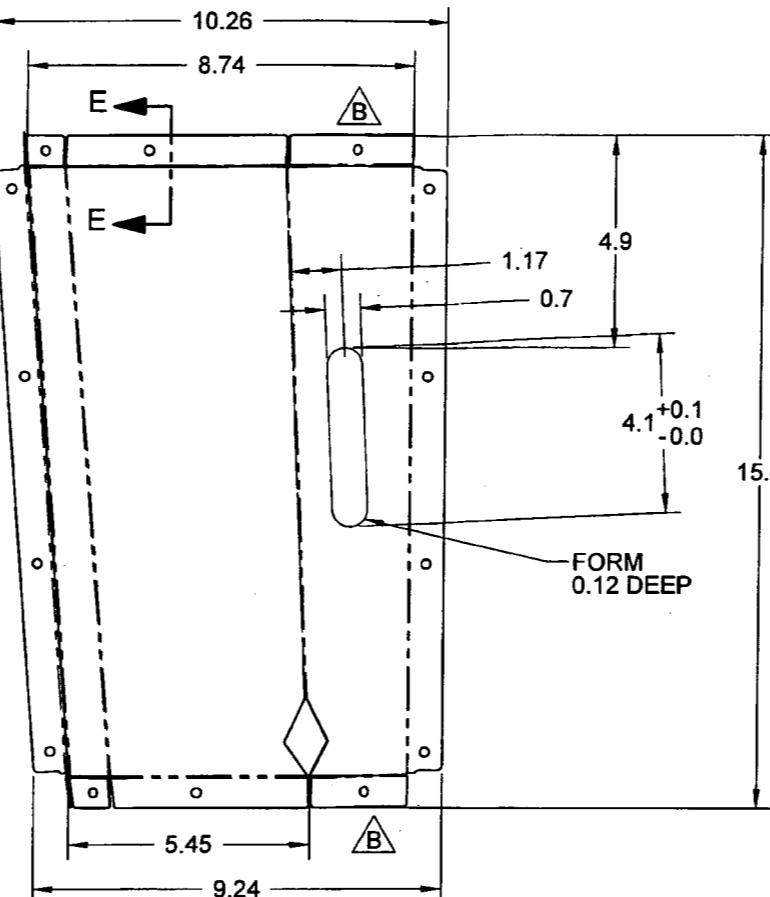
DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	DRAWING NO.
MFG. APPR.	MA	REV. B
APPROVED	TA	D3650
DE APPR.	TA	SHEET 4 OF 9
DATE	08.01.07	SCALE
		TOP PANEL ASSEMBLY
		1:3

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8 7 6 5 4 3 2 1



SECTION E-E



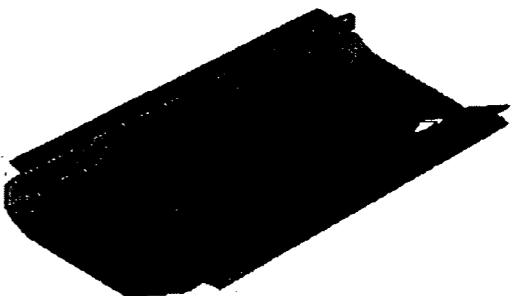
NOTES:
 1) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
 (MAKE FROM D3650-3F FLAT PATTERN)

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CHECKED	VE	DRAWING NO.	
MFG. APPR.		D3650	
APPROVED		REV. B	
DE APPR.		SHEET 5 OF 9	
DATE	08.01.07	TITLE TOP PANEL ASSEMBLY	
		SCALE 1:4	
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8 7 6 5 4 3 2 1



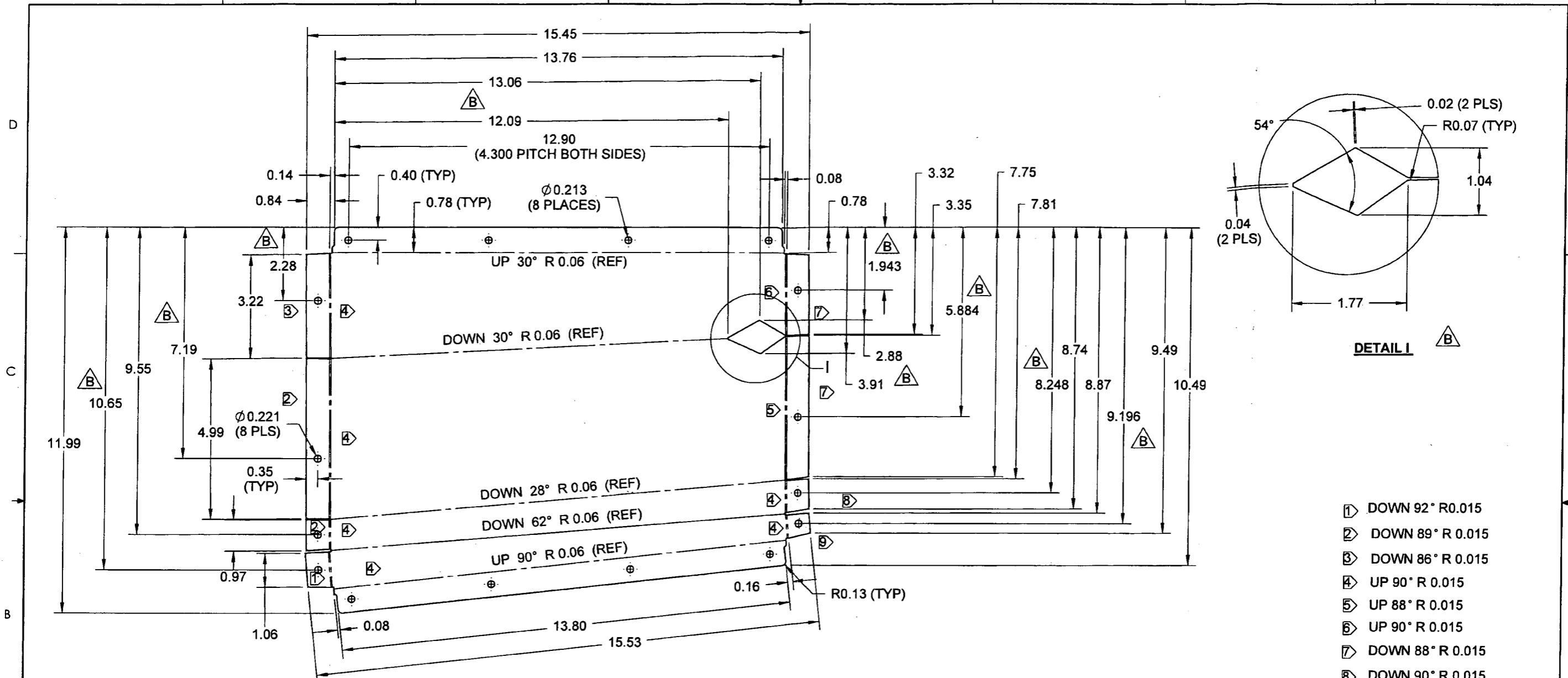
D

C

B

A

8 7 6 5 4 3 2 1



D3650-3F CENTER PANEL FLAT PATTERN

A
D3650-3F NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
 PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE

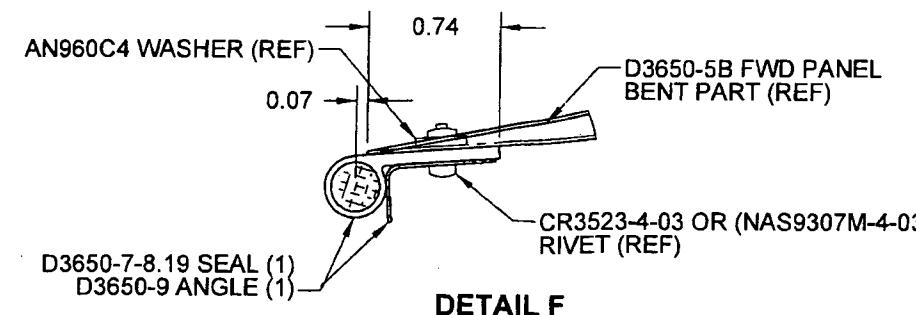
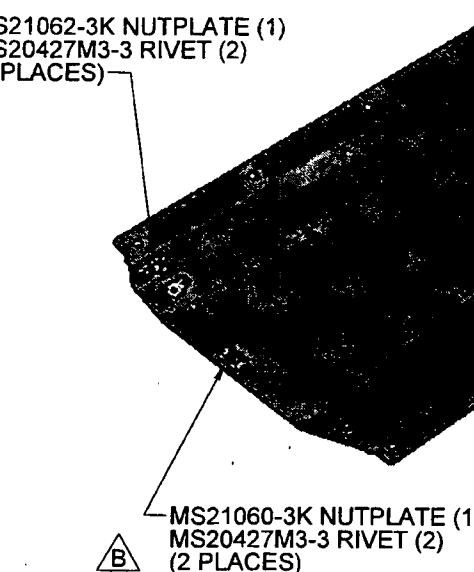
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	
MFG. APPR.	M	REV. B	
APPROVED	W	D3650	
DE APPR.	W	SHEET 6 OF 9	
DATE 08.01.07		TITLE TOP PANEL ASSEMBLY	
SCALE 1:3			

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08-03-27
NO. 30131

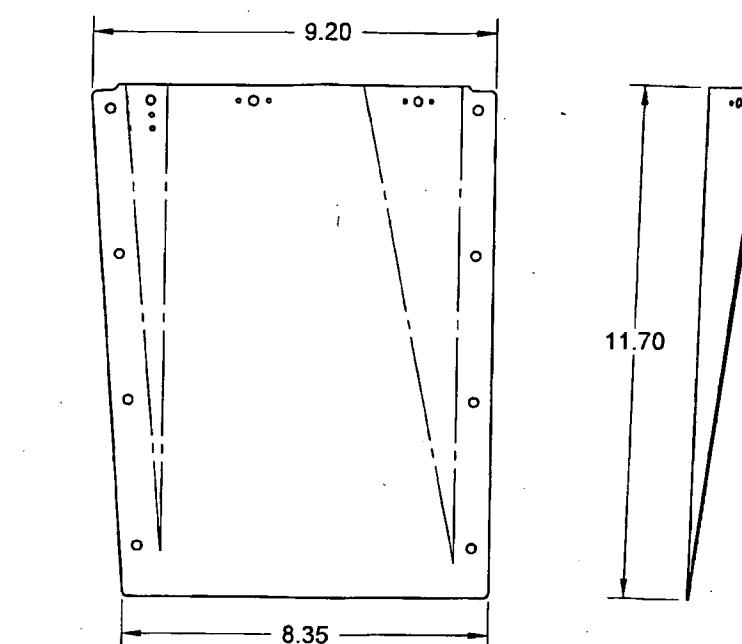
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DETAIL F



D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)

PART LIST

QTY	PART NUMBER	DESCRIPTION
5	X D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

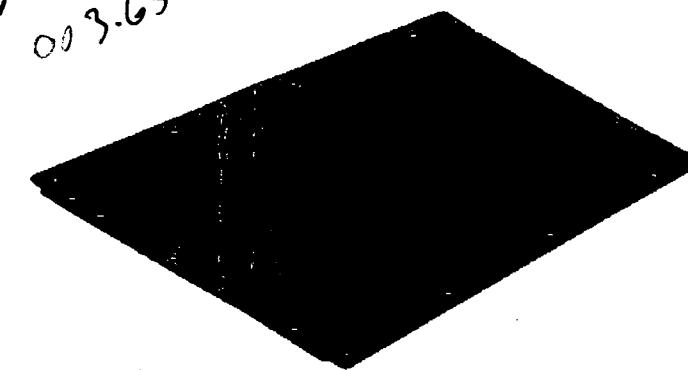
D3650-5 FWD PANEL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3650 TITLE TOP PANEL ASSEMBLY SCALE 1:4
DRAWN	RF	
CHECKED	LE	
MFG. APPR.	W	
APPROVED	MC	
DE APPR.	W	
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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WORK ORDER
NO. 31034

8 7 6 5 4 3 2 1

3 2 1

50 3.65
67 3.65
00 3.65

D

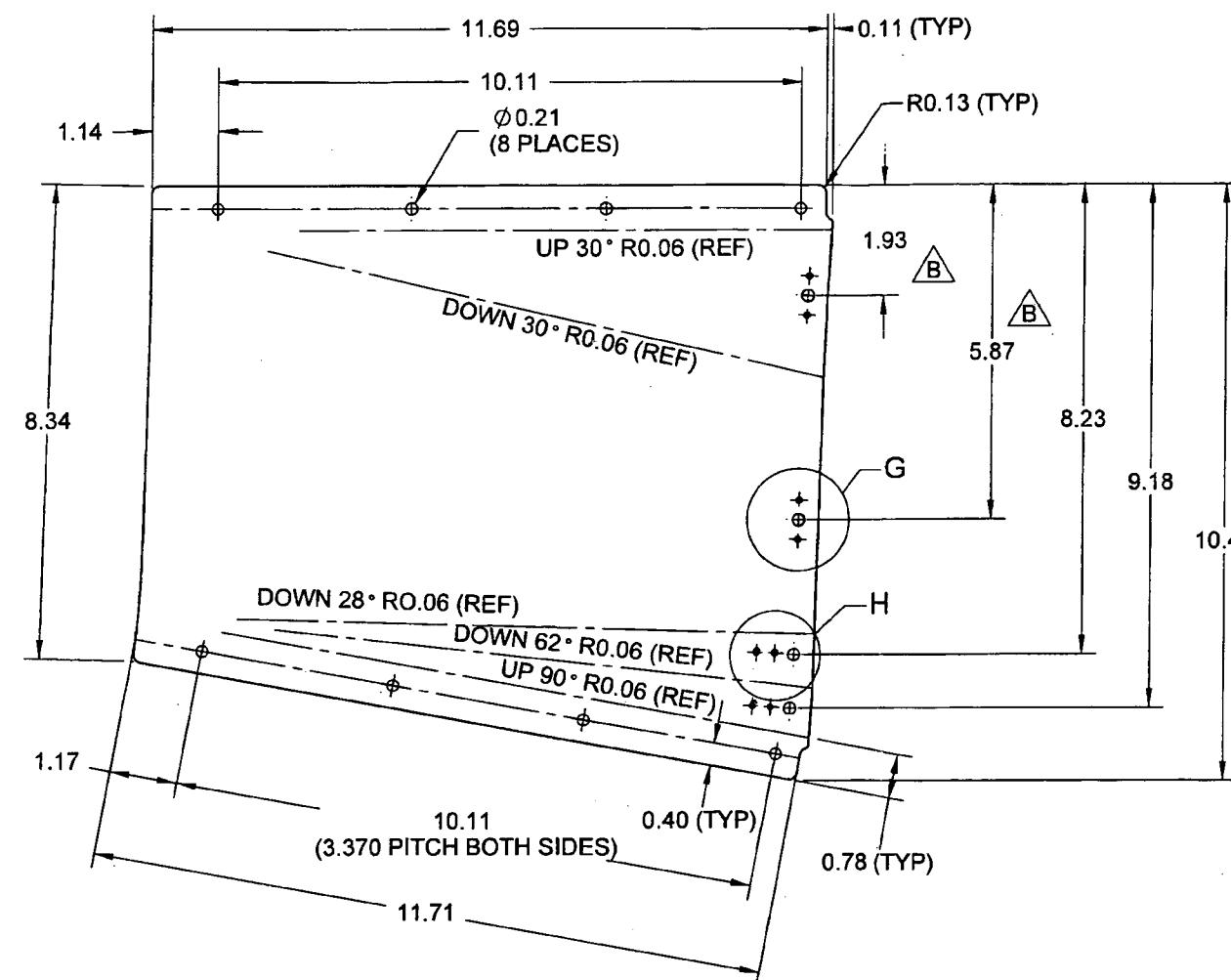
D

C

C

B

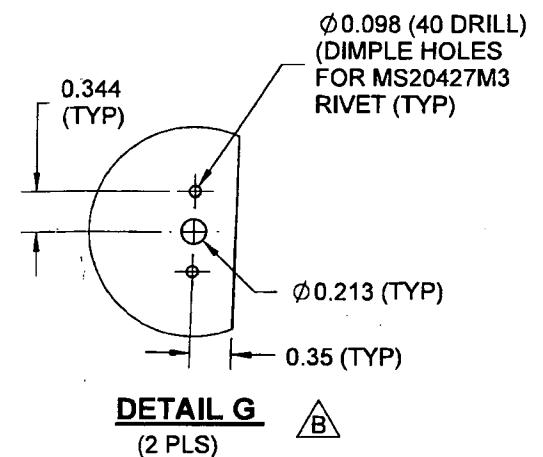
B



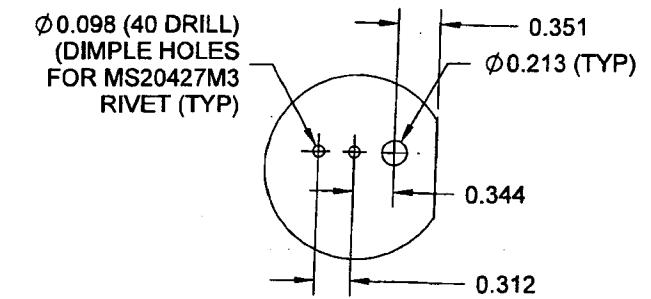
D3650-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb



DETAIL G
(2 PLS) **B**



DETAIL H
(2 PLS) **B**

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NO. *09331*

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>LE</i>	DRAWING NO.
MFG. APPR.	<i>NA</i>	REV. B
APPROVED	<i>NA</i>	D3650
DE APPR.	<i>NA</i>	SHEET 8 OF 9
DATE	08.01.07	TITLE
		SCALE
		1:3
		TOP PANEL ASSEMBLY
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